



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-591-312
Job Sheet 183536



Part No: D350-591-312

Job Qty: 1 ea

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/20/18

Job Tracking No:

Due Date: 10/24/18

Created By: Marie Lajeunesse

Type: SOLD

Description: NO-AIRBUS

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		10/24/18	0.00	0.00	Start Up Large Fab-4		SLN
110	Large Fab	1 pcs		10/24/18	0.00	1.00	Large Fab 2		SLN
120	QC	1 pcs		10/24/18	0.00	0.00	QC9		CPC
130	QC	1 pcs		10/24/18	0.00	0.00	QC5		CPC
140	HandFinish	1 pcs		10/24/18	0.00	0.19	HandFinish1		DR 18/09/25
150	QC	1 pcs		10/24/18	0.00	0.00	QC7-2		38
180	Large Fab	1 pcs		10/24/18	0.00	1.00	Large Fab 2		SLN 9-89
190	QC	1 pcs		10/24/18	0.00	0.00	QC10		38 DAS
200	QC	1 pcs		10/24/18	0.00	0.00	QC5		9-89 38
210	HandFinish	1 pcs		10/24/18	0.00	0.19	HandFinish1		DR 18/10/1
220	Powdercoat	1 pcs		10/24/18	0.00	0.30	Powdercoat1		BR 18-10-3
230	HandFinish	1 pcs		10/24/18	0.00	0.19	HandFinish3		BE 18-10-0 DAS
240	QC	1 pcs		10/24/18	0.00	0.00	QC3		OCT 09 2018 68
250	Packaging	1 pcs		10/24/18	0.00	0.00	Packaging1-3		DAS 9-89
260	QC	1 pcs		10/24/18	0.00	0.00	QC4		BB 68 OCT 11 2018
270	Packaging	1 pcs		10/24/18	0.00	0.00	Packaging3-1		BB 69 OCT 11 2018
275	DC	1 pcs		10/24/18	0.00	0.00	DC		9-89 OCT 11 2018
280	QC21-FG	1 Ea		10/24/18	0.00	0.00	QC21		DAS OCT 11 2018

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Descriptions: Dwg D3272 A/R Aluminum Rod M184785 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 1:55 OVEN TEMPERATURE: 320 FINISH TIME: 2:25

270 - Identify and pack for shipping as per PPPD350-591-312 Location :FG072

275 - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	2 Ea (2 ea)	90-Start up Operation	5104284
D3219-1	Plate	2 Ea (2 ea)	90-Start up Operation	5104284
D3272-1	Step	1 Ea (1 ea)	90-Start up Operation	5109677

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
		OTHER :							

D3065-041	Step Leg Assembly	1 Ea (1 ea)	180-Large Fab
D3066-1	Spacer	2 Ea (2 ea)	180-Large Fab
MS20600-AD4W4	Rivet	16 Ea (16 ea)	180-Large Fab
AN3-35A	Bolt	2 Ea (2 ea)	250-Packaging
AN4-13A	Bolt	8 Ea (8 ea)	250-Packaging
AN5-36A	Bolt	2 Ea (2 ea)	250-Packaging
D2230-3	Mounting Lug	4 Ea (4 ea)	250-Packaging
D2618	Bushing	2 Ea (2 ea)	250-Packaging
D2856-400-720	Abrasion Strip 4" X 7.20"	2 Ea (2 ea)	250-Packaging
D3235-1	Mounting Lug	2 Ea (2 ea)	250-Packaging
D3278-041	Support Assembly	1 Ea (1 ea)	250-Packaging
MS21042L3	Nut	2 Ea (2 ea)	250-Packaging
MS21042L4	Nut	8 Ea (8 ea)	250-Packaging
MS21042L5	Nut	2 Ea (2 ea)	250-Packaging
NAS1149D0363J	Washer	4 Ea (4 ea)	250-Packaging
NAS1149D0463J	Washer	16 Ea (16 ea)	250-Packaging
NAS1149D0563J	Washer	4 Ea (4 ea)	250-Packaging

S110595
S108216
S106978

D51 9410-011

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	2	119	0
	D3219-1	2	109	0
	D3272-1	1	1	0
180-Large Fab	D3065-041	1	18	0
	D3066-1	2	74	0
	MS20600-AD4W4	16	284	0
250-Packaging	AN3-35A	2	395	0
	AN4-13A	8	786	0
	AN5-36A	2	338	0
	D2230-3	4	203	0
	D2618	2	187	0
	D2856-400-720	2	226	0
	D3235-1	2	30	0
	D3278-041	1	0	0
	MS21042L3	2	3,192	0
	MS21042L4	8	4,030	0
	MS21042L5	2	856	0
	NAS1149D0363J	4	2,169	0
	NAS1149D0463J	16	7,088	0
	NAS1149D0563J	4	1,620	0

D51 9410-011

Part Specifications

Specifications could not be found.

5671

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rewo _____ Scri _____ Use-as _____ Suspected Unapprove _____		DART AEROSPACE 1270 Aberden Street Hamilton, ON K8A 1K7 CANADA TEL : 1 613 632 - 5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S112362 Part: D350-591-312 Job No: 183536 Serial No/Batch: S112362 D 350-591-312 S112362 REV. B Revision: _____ Inspector: _____ Exp Date: _____ Instructions: TC STC SH92-6 Issue 1 Date STC SH967NE 04/12/21, BRAZIL 1							
Date : _____		Step #: _____									
Description Work Order Deviation											
Root Cause <table border="0" style="width: 100%;"> <tr> <td style="width: 50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width: 50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	FAULT CATEGORY <table border="0" style="width: 100%;"> <tr> <td style="width: 33%;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width: 33%;"> Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width: 33%;"> Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> <td style="width: 33%;"> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> </table>				Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐										
Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐								
		OTHER : _____									



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D350-591-312
Job Sheet 183536



Part No: D350-591-312

Job Qty: 1 ea

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/20/18

Job Tracking No:

Due Date: 10/24/18

Created By: Marie Lajeunesse

Type: SOLD

Description: NO-AIRBUS

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		10/24/18	0.00	0.00	Start Up Large Fab-4		
110	Large Fab	1 pcs		10/24/18	0.00	1.00	Large Fab 2		
120	QC	1 pcs		10/24/18	0.00	0.00	QC9		
130	QC	1 pcs		10/24/18	0.00	0.00	QC5		
140	HandFinish	1 pcs		10/24/18	0.00	0.19	HandFinish1		
150	QC	1 pcs		10/24/18	0.00	0.00	QC7-2		
180	Large Fab	1 pcs		10/24/18	0.00	1.00	Large Fab 2		
190	QC	1 pcs		10/24/18	0.00	0.00	QC10		
200	QC	1 pcs		10/24/18	0.00	0.00	QC5		
210	HandFinish	1 pcs		10/24/18	0.00	0.19	HandFinish1		
220	Powdercoat	1 pcs		10/24/18	0.00	0.30	Powdercoat1		
230	HandFinish	1 pcs		10/24/18	0.00	0.19	HandFinish3		
240	QC	1 pcs		10/24/18	0.00	0.00	QC3		
250	Packaging	1 pcs		10/24/18	0.00	0.00	Packaging1-3		
260	QC	1 pcs		10/24/18	0.00	0.00	QC4		
270	Packaging	1 pcs		10/24/18	0.00	0.00	Packaging3-1		
275	DC	1 pcs		10/24/18	0.00	0.00	DC		
280	QC21-FG	1 Ea		10/24/18	0.00	0.00	QC21		

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Descriptions: Dwg D3272 A/R Aluminum Rod 3-Grind End Plate flush
180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.
220 - START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____
270 - Identify and pack for shipping as per PPPD350-591-312 Location :FG072
275 - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	2 Ea (2 ea)	90-Start up Operation	
D3219-1	Plate	2 Ea (2 ea)	90-Start up Operation	
D3272-1	Step	1 Ea (1 ea)	90-Start up Operation	

D3065-041	Step Leg Assembly	1 Ea (1 ea)	180-Large Fab
D3066-1	Spacer	2 Ea (2 ea)	180-Large Fab
MS20600-AD4W4	Rivet	16 Ea (16 ea)	180-Large Fab
AN3-35A	Bolt	2 Ea (2 ea)	250-Packaging
AN4-13A	Bolt	8 Ea (8 ea)	250-Packaging
AN5-36A	Bolt	2 Ea (2 ea)	250-Packaging
D2230-3	Mounting Lug	4 Ea (4 ea)	250-Packaging
D2618	Bushing	2 Ea (2 ea)	250-Packaging
D2856-400-720	Abrasion Strip 4" X 7.20"	2 Ea (2 ea)	250-Packaging
D3235-1	Mounting Lug	2 Ea (2 ea)	250-Packaging
D3278-041	Support Assembly	1 Ea (1 ea)	250-Packaging
MS21042L3	Nut	2 Ea (2 ea)	250-Packaging
MS21042L4	Nut	8 Ea (8 ea)	250-Packaging
MS21042L5	Nut	2 Ea (2 ea)	250-Packaging
NAS1149D0363J	Washer	4 Ea (4 ea)	250-Packaging
NAS1149D0463J	Washer	16 Ea (16 ea)	250-Packaging
NAS1149D0563J	Washer	4 Ea (4 ea)	250-Packaging

DSI 9410-011

5110095
5105216
5100910
5101329
5089302
5099504
5110581
5089996
5104552
513205
5114310
5094592
5094597
5083501
5095293
5089299
5093723
5103492

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	2	119	0
	D3219-1	2	109	0
	D3272-1	1	1	0
180-Large Fab	D3065-041	1	18	0
	D3066-1	2	74	0
	MS20600-AD4W4	16	284	0
250-Packaging	AN3-35A	2	395	0
	AN4-13A	8	786	0
	AN5-36A	2	338	0
	D2230-3	4	203	0
	D2618	2	187	0
	D2856-400-720	2	226	0
	D3235-1	2	30	0
	D3278-041	1	0	0
	MS21042L3	2	3,192	0
	MS21042L4	8	4,030	0
	MS21042L5	2	856	0
	NAS1149D0363J	4	2,169	0
	NAS1149D0463J	16	7,088	0
	NAS1149D0563J	4	1,620	0

Part Specifications

Specifications could not be found.

Change Record

PAGE 1 OF 2

Part Number: D350-591-311/-312 (EURO P/N: 704A 41 640 012/-011)

Description: HELI-ACCESS STEP, HIGH SKID, LONG STEP, LH/RH

[illegible]